

Date: Thursday, 09/10/2008 10:20:18 AM
 User: Julie Lecocq

Process Sheet

Customer : CC-DAR01 Dart Aerospace Ltd.	Drawing Name : SEAT SUPPORT ASSEMBLY, LH
Job Number : 42519	
Estimate Number : 13328	
P.O. Number :	Part Number : D3784043
This Issue : 09/10/2008 S.O. No. :	Drawing Number : D3784 REVB
Prsht Rev. : NC	Project Number :
First Issue : // Type : SMALL /MED FAB	Drawing Revision : B
Previous Run : 40878	Material :
Written By :	Due Date : 25/10/2008 Qty: 1 Um: Each
Checked & Approved By : <u>JUD 08.10.09</u>	
Comment : Est Rev:A 08-05-19 new issue DD verified by:ec Est Rev:B 08-07-18 revB as per dwg DD verified by:EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	PACKAGING 1	PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
 Pick Packing Kit

2.0	D3763043	End Fitting Assembly, LH
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
 End Fitting Assembly, LH
 batch: 40958

SQ

3.0	D37701	Tube
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
 Tube
 batch: 40978

SQ

4.0	D37703	Tube
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
 Tube
 batch: B 40979

SQ

5.0	D3763041	End Fitting Assembly
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
 End Fitting Assembly
 batch: 41052

8/10/9

(X)

SQ

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 09/10/2008 10:20:18 AM
User: Julie Lecocq

Process Sheet

Customer: CC-DAR01 Dart Aerospace Ltd.

Drawing Name: SEAT SUPPORT ASSEMBLY, LH

Job Number: 42519

Part Number: D3784043

Job Number:



Seq. #: Machine Or Operation: Description :

6.0 AN960JD10L Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Washer

batch: M105793

(or NAS1149Do332J) batch: _____

SLP

7.0 MS21042L3 Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Nut

batch: M1027 M102217 M104623

SLP

8.0 AN52510R20 Screw



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Screw

batch: M108559

SLP

(2)

SLP

9.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-assemble as per dwg D3784

****Note 8: Hole "A" is located 5" from the end of D3770-3 tube and must be oriented up****

****Note 8: Hole "B" is located 5" from the end of D3770-1 tube and must be oriented AFT****

SLP 08/10/14 (1)

10.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SLP 08/10/14 (2)

11.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with Dart part # and batch # using a fine point permanent marker on inside of part and Stock

Location: ST 251

SLP 08/10/14 (3)

12.0 QC21 FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

SLP 08/10/15 (4)

Job Completion



MF 08-10-15

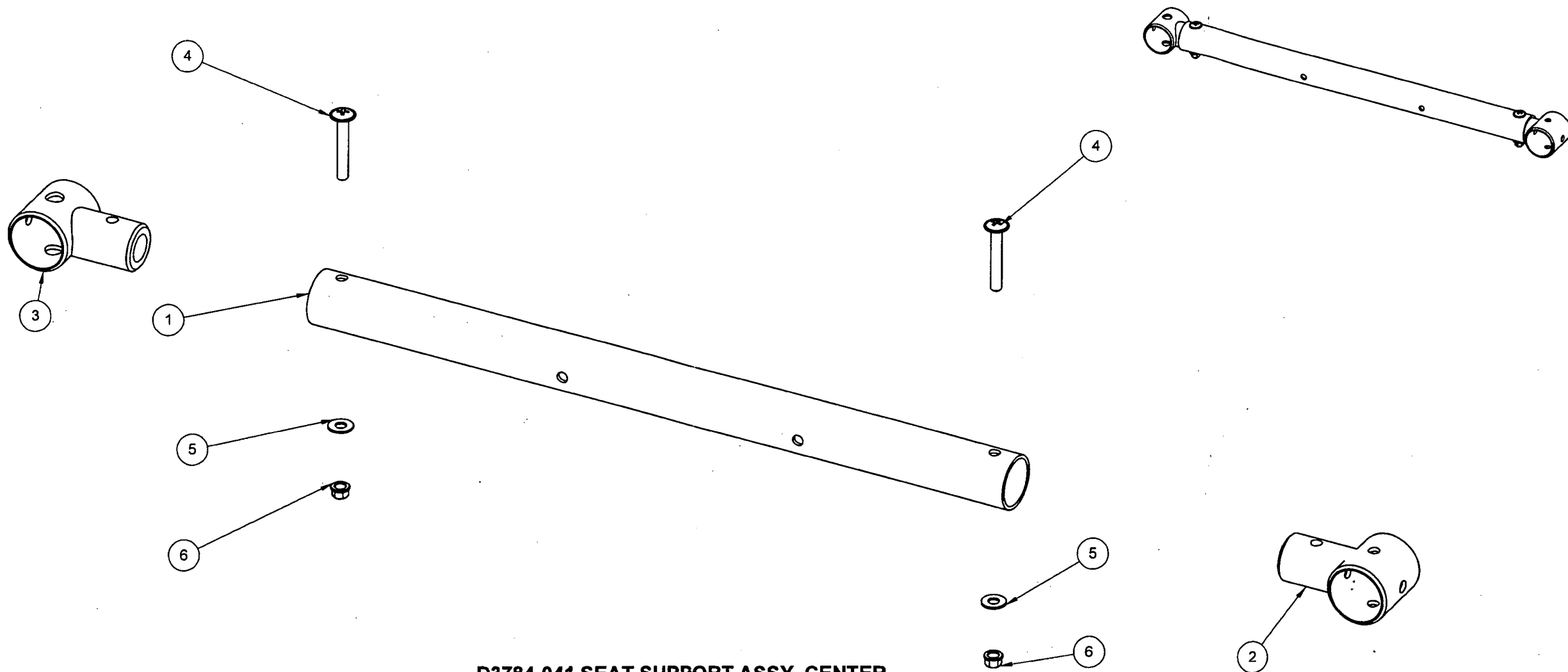
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3784-041 SEAT SUPPORT ASSY, CENTER

ITEM NO.	PART NUMBER	DESCRIPTION	QTY. (-041)
1	D3770-1	TUBE	1
2	D3763-041	END FITTING ASSY	1
3	D3763-045	END FITTING ASSY	1
4	AN525-10R20	SCREW	2
5	NAS1149D0332J	WASHER (AN960JD10L)	2
6	MS21042L3	NUT	2

△
△
△
△
△
△
△
△

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.31 lbs

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WORK ORDER

RELEASED
08.07.10
42519

B	HARDWARE CHANGE, ASSY CHANGE	HS	08.06.23
A	NEW ISSUE	HS	08.06.04
REV.	DESCRIPTION	BY	DATE
DESIGN	HS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	HS		
CHECKED	HS	DRAWING NO.	REV. B
MFG. APPR.	HS	D3784	SHEET 1 OF 5
APPROVED	HS	TITLE	SCALE
DE APPR.	HS	SEAT SUPPORT ASSEMBLY	NTS
DATE	08.06.23	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

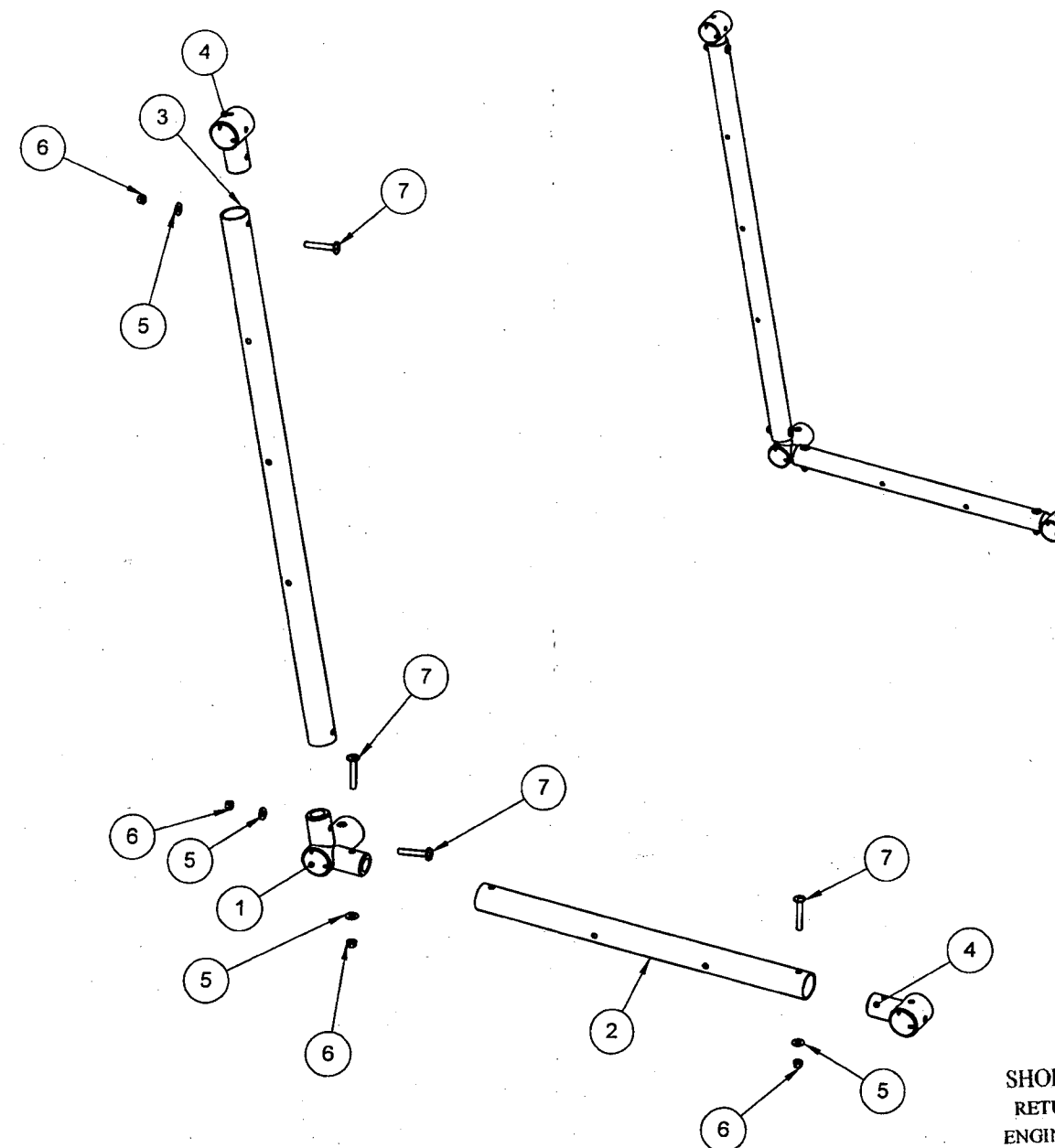
ITEM NO.	PART NUMBER	DESCRIPTION	QTY. (-043)
1	D3763-043	END FITTING ASSY, LH	1
2	D3770-1	TUBE	1
3	D3770-3	TUBE	1
4	D3763-041	END FITTING ASSY	2
5	NAS1149D0332J	WASHER (AN960JD10L)	4
6	MS21042L3	NUT	4
7	AN525-10R20	SCREW	4

B
B
B

D3784-043 SEAT SUPPORT ASSY, LH

NOTES:

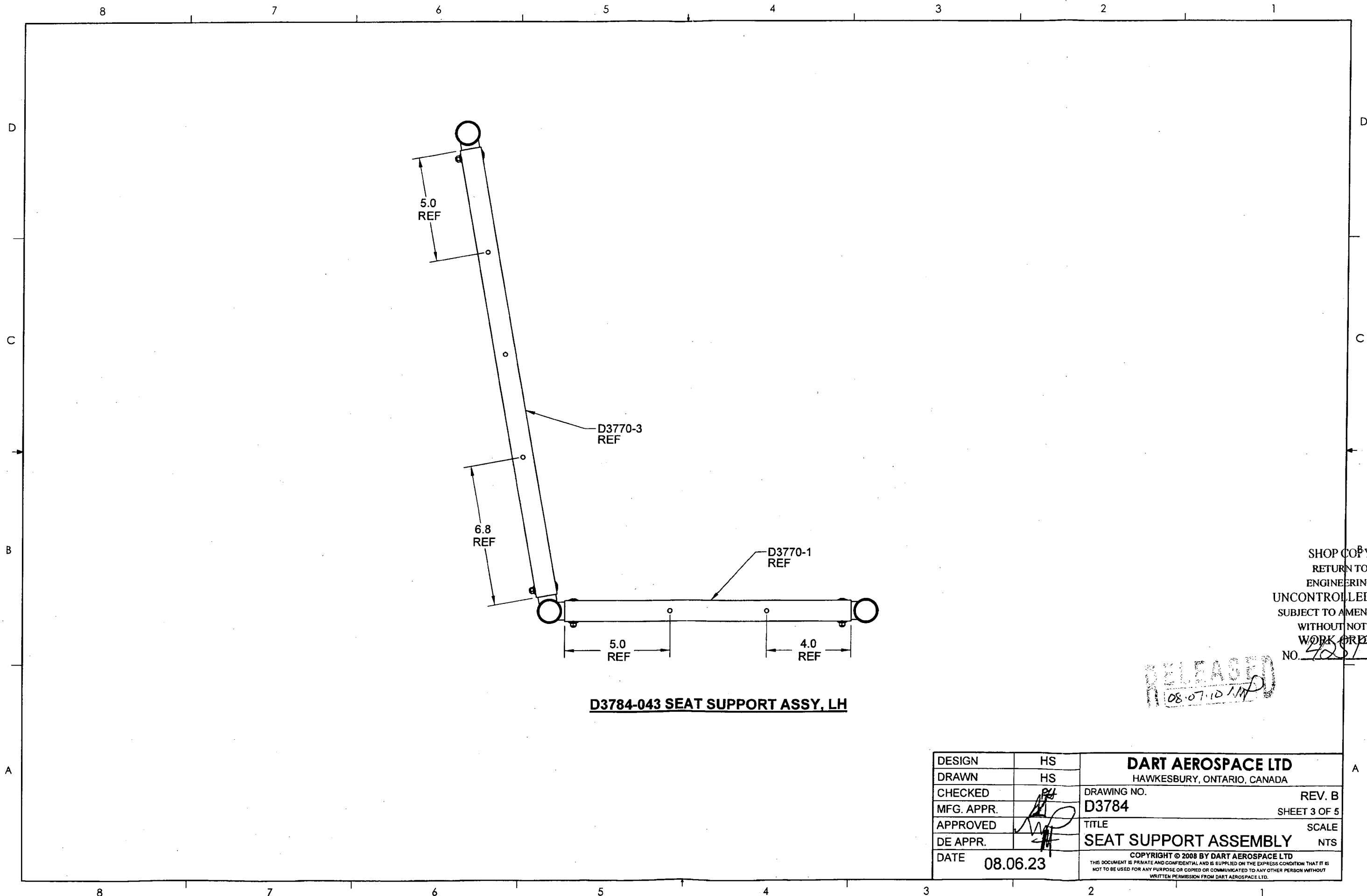
- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.78 lbs



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08.07.10/11

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MFG. APPR.	NO	D3784	SHEET 2 OF 5
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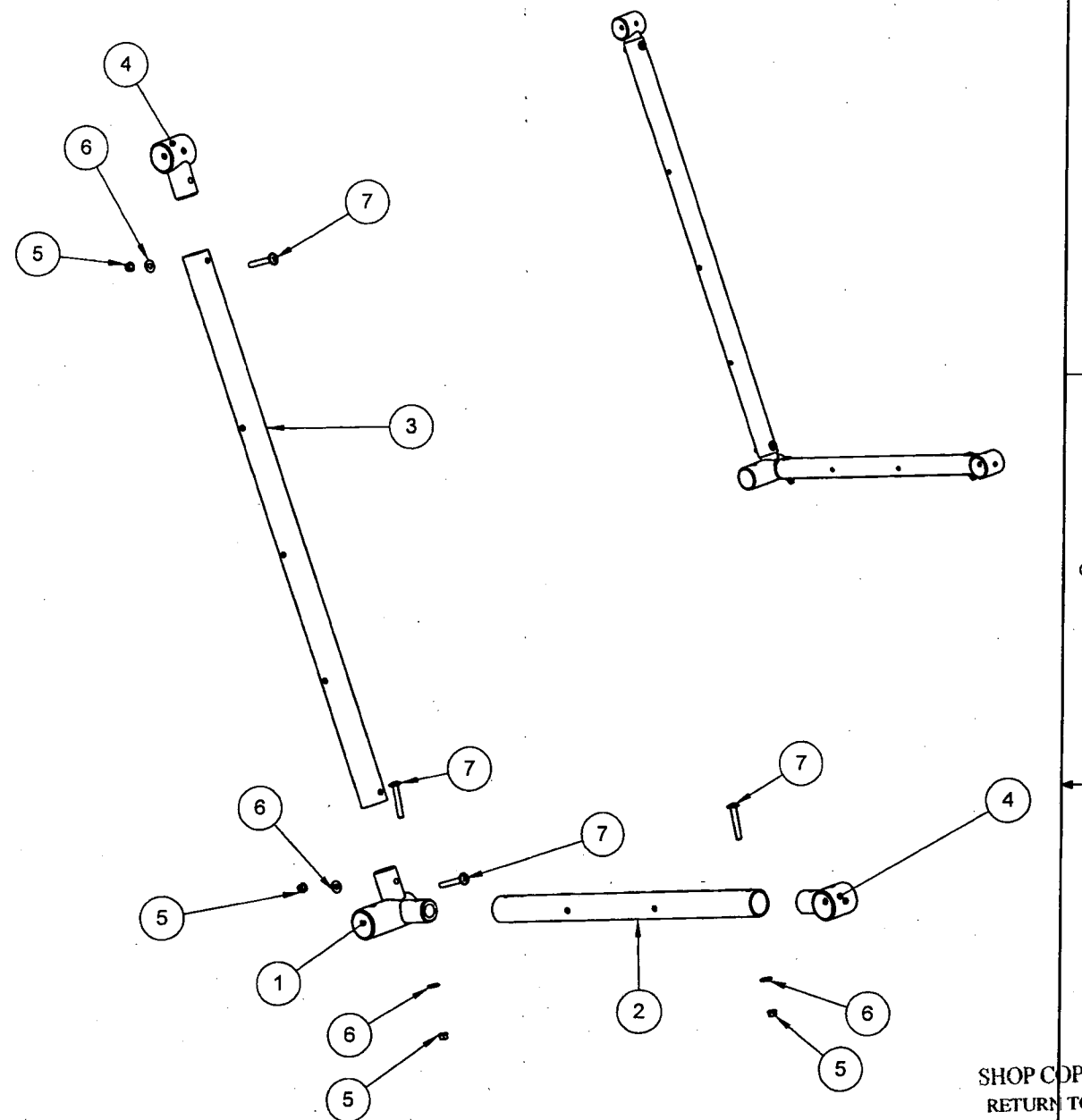
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MFG. APPR.	AP	D3784	SHEET 3 OF 5
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ITEM NO.	PART NUMBER	DESCRIPTION	QTY. (-044)
1	D3763-044	END FITTING ASSY, RH	1
2	D3770-1	TUBE	1
3	D3770-3	TUBE	1
4	D3763-041	END FITTING ASSY	2
5	MS21042L3	NUT	4
6	NAS1149D0332J	WASHER (AN960JD10L)	4
7	AN525-10R20	SCREW	4

△
B
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B
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B



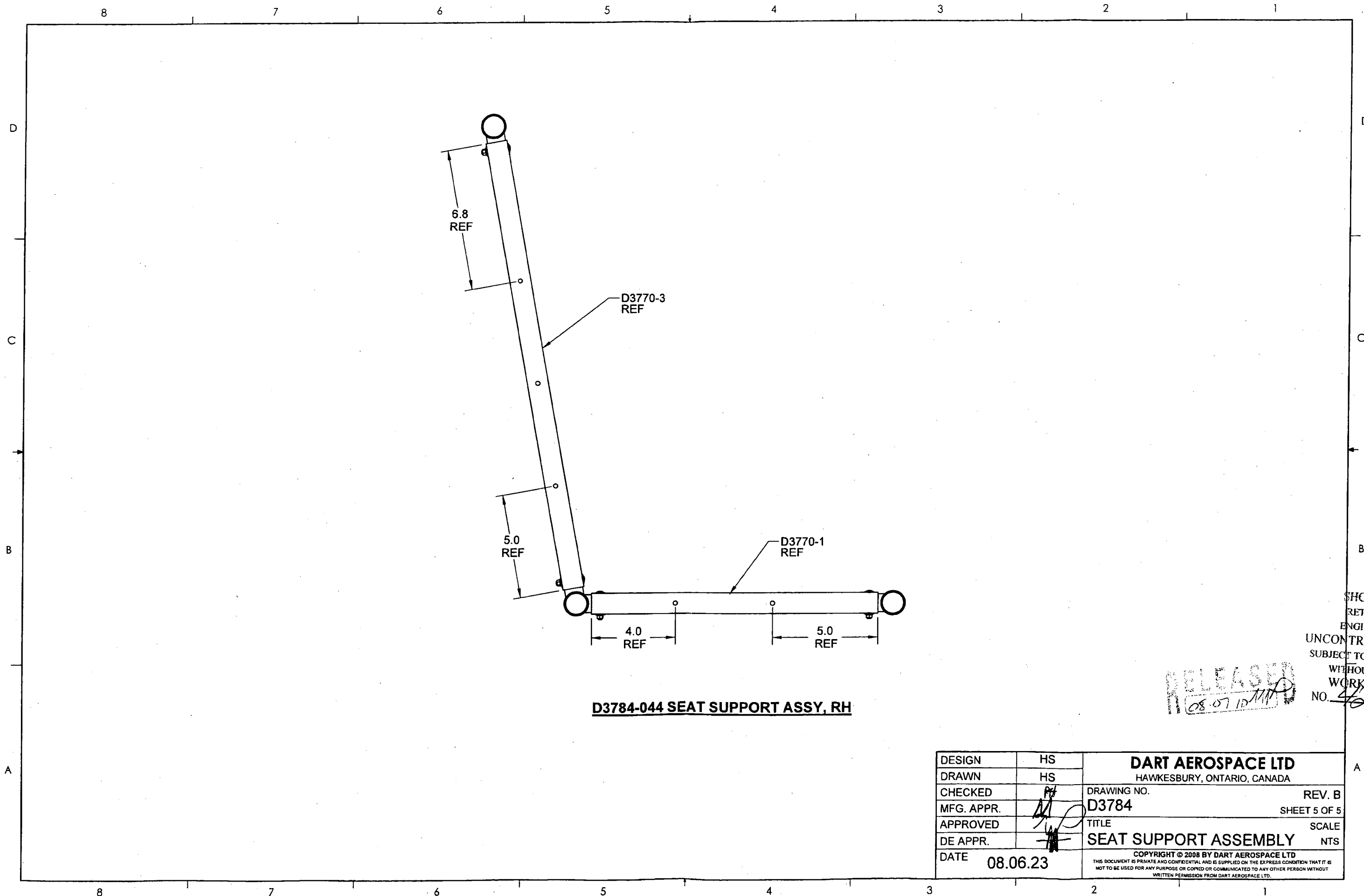
D3784-044 SEAT SUPPORT ASSY, RH

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.78 lbs

DESIGN	HS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
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APPROVED	<i>[Signature]</i>	TITLE SEAT SUPPORT ASSEMBLY
DE APPR.	<i>[Signature]</i>	SCALE NTS
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08.07.10

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CHECKED	PH	DRAWING NO.	REV. B
MFG. APPR.	M	D3784	SHEET 5 OF 5
APPROVED	PH	TITLE	SCALE
DE APPR.	PH	SEAT SUPPORT ASSEMBLY	NTS
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